

Date: Thursday, 01/05/2008 12:48:25 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 205 SKIDTUBE "I" BEAM		
Job Number	: 38951		Part Number	: D2596		
Estimate Number	: 10346		Drawing Number	: D2596 REV D		
P.O. Number	:		Project Number	: N/A		
This Issue	: 01/05/2008	S.O. No. :	Drawing Revision	: D		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : SKIDTUBES	Due Date	: 10/05/2008	Qty:	4
Previous Run	: 38660		Um:	Each		
Written By	:					
Checked & Approved By	: JUO 08.5d					
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M Est Rev:E 07-07-09 Incorporated DEO 9183 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ex'tn - 'I' Beam Web 4"	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 Extrusion B33940 DP 8-5-2			
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr DP 8-5-2			
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1 DP 8-5-2			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP S 080512 67			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 16

DP 85-2

(4)

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/05 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



JF 08-05-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

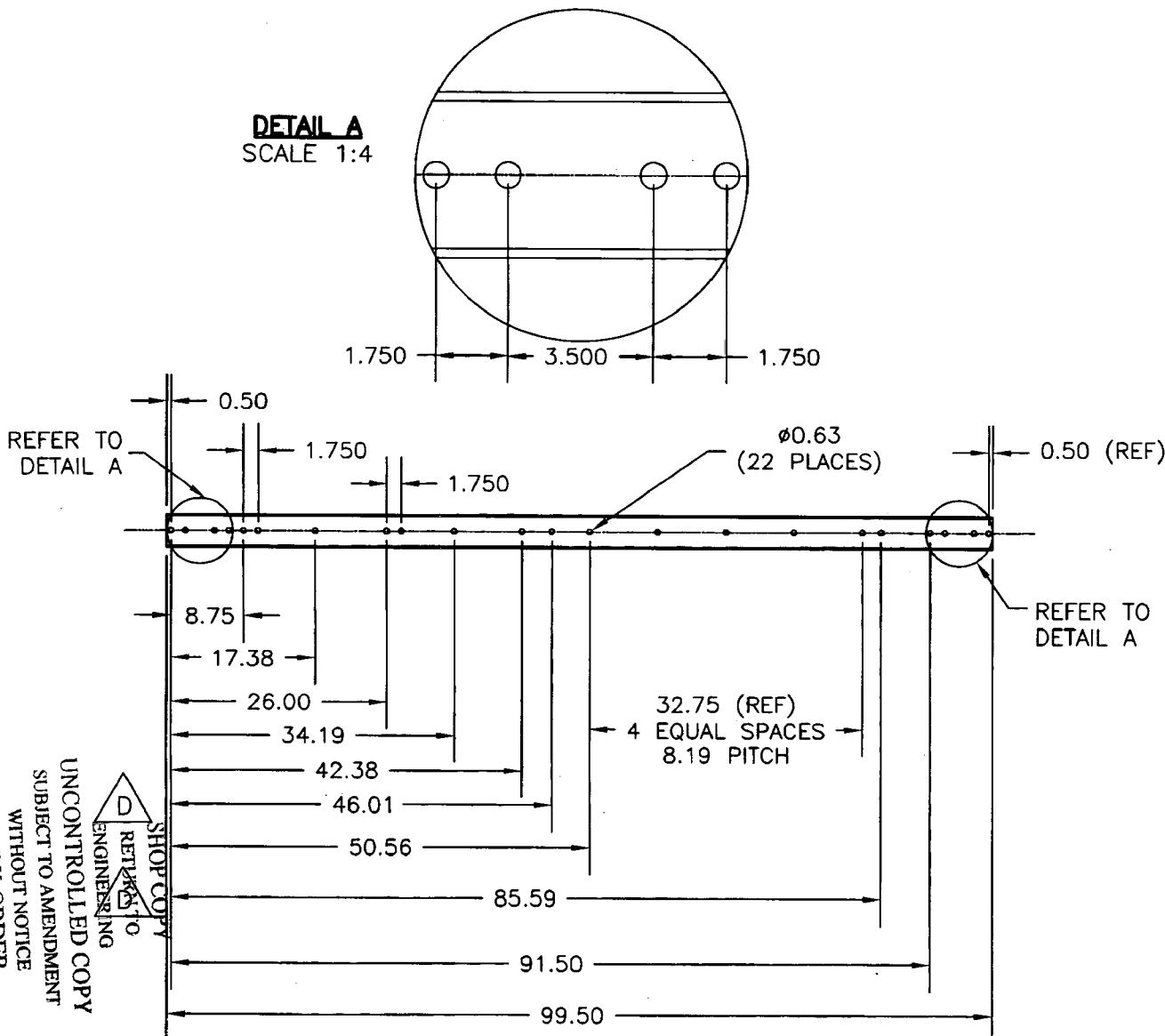
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07/04/98

DESIGN <i>RH</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>M</i>	APPROVED <i>M</i>	REV. D
DATE 07.04.17	DRAWING NO. D2596	SHEET 1 OF 1
A	96.09.16	NEW ISSUE
B	97.07.23	$\phi 0.63$ HOLE WAS $\phi 0.56$
C	98.09.14	INCORPORATED DEC 9097
D	07.04.17	INCORPORATED DEC 9183

**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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